

PRELIMINARY ISSUE

Work Order ID 61936

Friday, September 10, 2010 9:44:06 AM

Page 1



Item ID: D4172-044

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Z-Shape Section Assembly, RH

Stop



Start Date: 9/10/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-9-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4172	PA2 10.09.16

100

0.00



Small Fab

Memo

0.00

BT 10-09-21

Small Fab

Memo
1- Transfer drill holes, deburr and assemble as per dwg



110

QC5- Inspect part completeness to step on W/O

0.00 - *inspected to PA2*

QC

Memo

0.00

Day only
10/09/22 *①*

Quality Control

120

Identify as per dwg & Stock Location: *compos* *yes*

0.00

Packaging

Memo

0.00

Packaging

BT 10-09-21

W/O: 61936		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-09-22	100	rivets along angled top piece installed facing outward non permanent change <i>Acceptable 10-09-22</i>	BT	10-09-22	1	10-09-22	

Part No: D4172-044 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-09-22	100	I rivet not seated properly		remove + re install new rivet ex 5213-1-04 in 104141 N/A	BT 10-09-22			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID**

130



QC

Quality Control

**Operation
Description**

QC21- Final Inspection - Work Order Release

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

**Plan
Code**Accept
QtyReject
QtyReject
NumberInsp.
Stamp

10/09/29/10

Memo

0.00

10/09/23

POSITIVE RECALLEFFECTIVE 10-09-13 AUTH URELEASED U DATE 10-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, September 10, 2010 9:44:10 AM

Work Order ID: 61936



Parent Item: D4172-044



Parent Item Name: Z-Shape Section Assembly, RH

Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

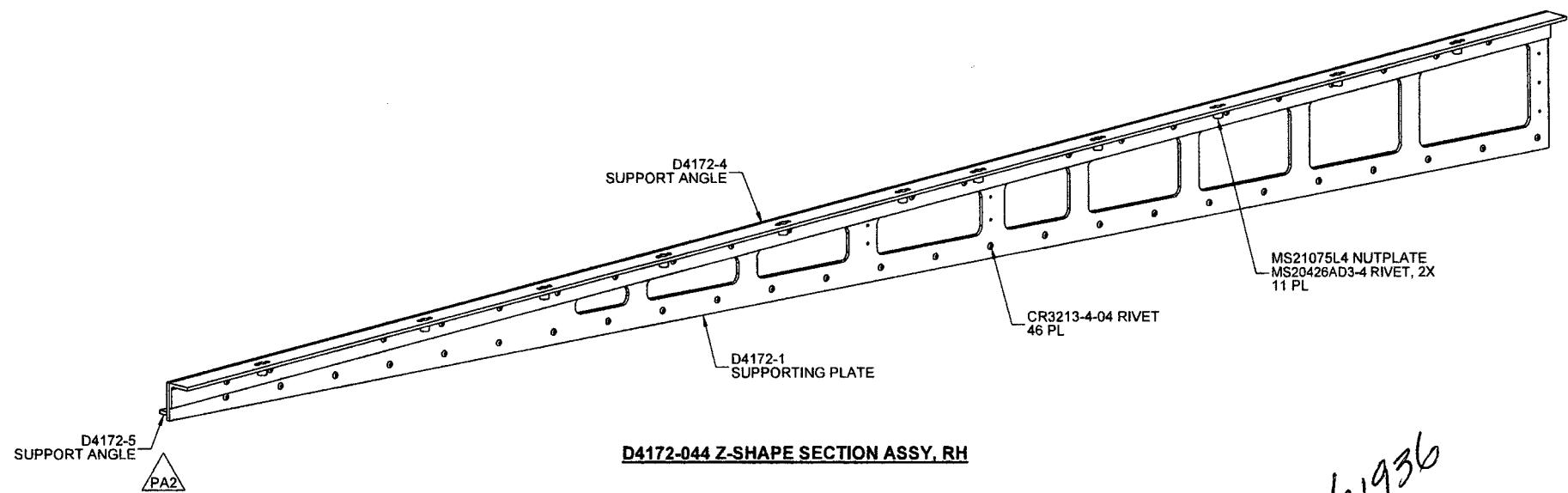
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
		X	D4172-044
			Z-SHAPE SECTION ASSY, RH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-4	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-4	RIVET
6	11	MS21075L4	NUT PLATE

PA2



D4172-044 Z-SHAPE SECTION ASSY, RH

NOTES:
 1) MATERIAL: NONE
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.14 lbs

PRELIMINARY ISSUE

10.09.15

DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED			
MFG. APPR.		DRAWING NO.	REV. PA2
APPROVED		D4172	SHEET 3 OF 7
DE APPR.		TITLE	SCALE
		POD MOUNTING FRAME ASSY	NTS
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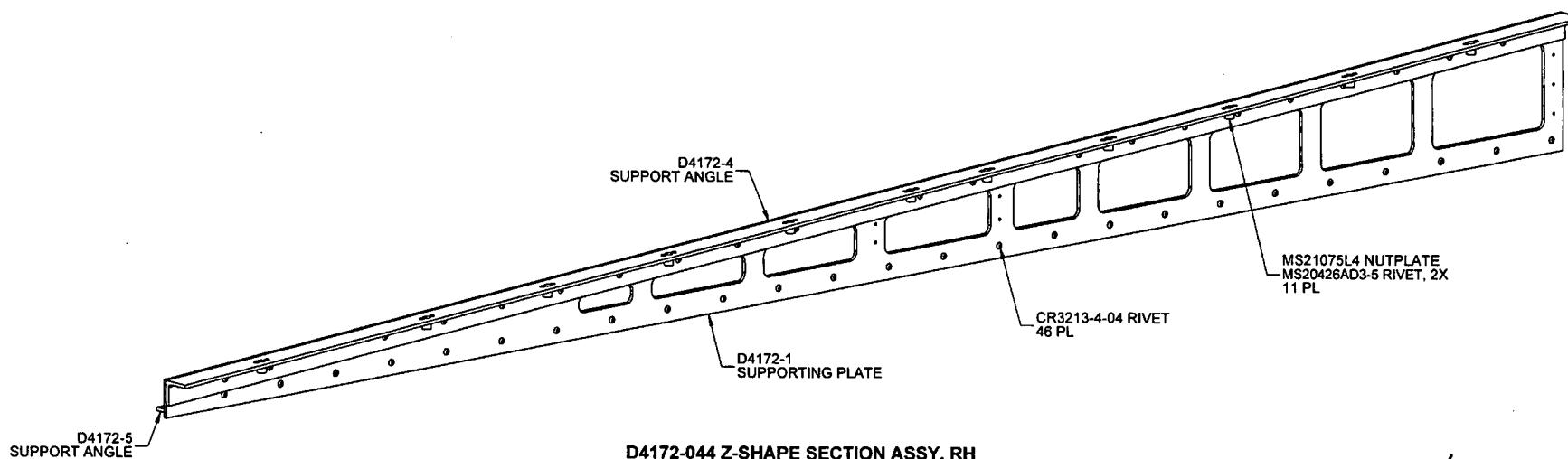
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C

B

A

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6	11	MS21075L4	NUT PLATE



D4172-044 Z-SHAPE SECTION ASSY, RH

61936
RELEASED
2010-09-29
M

NOTES:

- 1) MATERIAL: NONE
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MFG. APPR.	<i>10</i>	DRAWING NO.	D4172
APPROVED	<i>10</i>	SHEET 3 OF 7	
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